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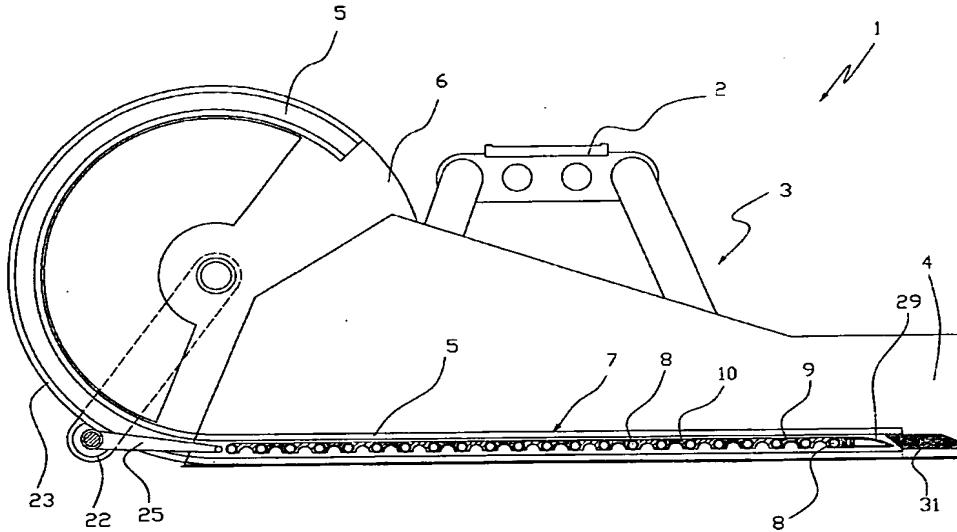
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(54) Title: HANDLING UNIT FOR PALLETIZING



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(57) Abstract: A handling unit (1) for palletizing, comprising: - a support (2) for coupling to manipulator means; - a framework (3) associated with said support (2) and defining an aperture; - a pair of parallel opposing slide rails (5) fixed to said framework (3); - at least one flexible sliding panel (5) slidable along said rails (5) between an extended position in which it completely closes said aperture to enable it to support articles to be palletized, and a retracted position in which it opens said aperture to enable said articles to fall through said aperture; - drive means (18, 19) for sliding said panel (7) along said rails (5).



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HANDLING UNIT FOR PALLETIZING

TECHNICAL FIELD

The present invention relates to a handling unit for palletizing.

5 More particularly, the present invention relates to a unit manipulated by a transfer system (e.g. a portal crane or a robot) for rapid automatic palletizing of goods.

PRIOR ART

10 Palletizing consists of organizing the arrangement and packaging of goods such as to make it possible to use loading pallets in goods transport and storage.

For palletizing, it is known to use palletizers which comprise separate units performing specific activities necessary to complete palletizing.

15

DISCLOSURE OF THE INVENTION

The object of the present invention is to provide a handling unit for palletizing in accordance with claim 1.

20 The dependent claims define particularly advantageous preferred embodiments of the handling unit of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

Further characteristics and advantages of the invention will be apparent on reading the ensuing description provided by way of non-limiting example, with the aid of the figures shown in the accompanying drawings, 25 in which:

Figure 1 is a side view of a handling unit according to the invention, with its sliding panel shown in section in the extended position;

Figure 2 shows the unit of Figure 1 with its sliding panel in the retracted position;

5 Figure 3 is a section on the line III-III of Figure 2;

Figures 4A and 4B show enlarged details of Figure 3;

Figure 5 shows a loading stage of the unit of Figure 1;

Figure 6 shows a second embodiment of the handling unit of the invention;

10 Figure 7 is a schematic view of the unit of Figure 1 from above, with the loading trolley in its jutting position;

Figure 8 is a front schematic view of the unit 1 provided with means for taking and releasing slip sheets;

15 Figures 9 and 10 are a side view of the surround taking and release means, with the surround shown raised and to be raised respectively.

BEST MODE FOR CARRYING OUT THE INVENTION

With reference to said figures, the reference numeral 1 indicates overall a handling unit according to the present invention.

20 Said handling unit 1 comprises a support 2 for coupling to manipulator means, such as a portal crane or a robot, not shown, operated by a control unit controlled by suitably programmed software.

The unit 1 comprises a framework, indicated overall by 3, lowerly defining an aperture for the fall of articles to be palletized.

25 Said framework 3 comprises a pair of vertically extending opposing side walls 4, of which only one is visible in the figures, associated with the

coupling support 2 and disposed parallel to each other.

According to the present invention, the framework 3 is provided with a pair of opposing parallel rails 5 a first section of which extends along two circumferential portions and a second section horizontally along the two

5 side walls 4.

Preferably, the first section of rail 5, which extends along the circumferential portion, lies external to the two side walls 4 and coaxial to a pair of circular protection walls 6.

In the example, each rail 5 is in the form of a C-shaped slide groove.

10 The opposing grooves 5 house a sliding panel in the form of a rolling shutter 7 able to slide between an extended position (Figure 1) in which it completely closes the lower aperture of the framework 3, and a retracted position (Figure 2) in which it opens this aperture.

When in its extended position, the rolling shutter 7 is able to handle a load 15 of articles positioned on it; in passing from its extended position to its retracted position, the rolling shutter 7 releases the articles to be palletized through the lower aperture of the framework 3.

The rolling shutter 7 is made to slide by suitable drive means described in detail hereinafter.

20 According to a preferred embodiment of the present invention, the rolling shutter 7 comprises a plurality of parallel tubular bars or rods 8 connected together by two opposing series of mutually offset chain links 9, 10 (Figure 3).

Said chain links are in the form of a first series of blocks 9 connecting 25 together consecutive pairs of rods 8 and a second series of blocks 10 offset from the blocks 9 of the first series and connecting together the two

adjacent rods 8 of one and the next pair connected together by the blocks 9 of the first series (Figure 4A).

As can be seen in Figure 4B, a bush 11 is inserted as an exact fit into each end of the rods 8, enabling the block 9 to be fixed by a pin 12

5 presenting on the central portion of its axial length a key seat 13 which abuts against the block 9, which is of cup shape in the region in which it is in contact with the end of the rod 8.

On that portion of the pin 12 distant from that screwed into the bush 11 there are mounted, starting from the key seat 13, a washer 14, the block

10 10, a spacer 15, a bearing 16 and finally a clamping screw 17 screwed into a threaded cavity provided at that end of the pin 12 opposite that screwed into the bush 11.

The bearings 16 enable the rolling shutter to slide within the guides 5 with less friction.

15 According to the present invention, the drive means are in the form of a gearmotor 18 (Figure 4A) rotating a first movable drive pinion 19 engaging a fixed first rack 20 carrying one of the two first circumferential sections of rail 5 and extending perimetraly about one of the two circular elements 6.

The first drive pinion 19 is keyed axially onto the end of a drive bar or

20 shaft 21, on the opposite end of which there is keyed a second movable drive pinion 22 engaging a second fixed rack 23, parallel to the first rack 20, carrying the other first circumferential section of rail 5 and extending perimetraly about the other circular element 6.

The pinions 19, 22 are maintained constantly engaged with the first rack

25 20 and second rack 23 respectively by a pair of rigid arms 24, acting as spacers, rotatably associated, in accordance with the known art, with the

respective centres of the opposing circular elements 6, concentric with the circumferential portion of the first section of the rails 5.

The pinions 19, 22 are associated with the rolling shutter 7 via a pair of opposing connecting rods 25 (Figures 1, 2).

5 Essentially, the rolling shutter 7 is made to slide along the grooves 5 by rotating the drive pinions 19 and 22, which rotate along the racks 20, 23 to drag the rolling shutter 7 connected to the shaft 21 by the connecting rods 25.

To enable the drive shaft of the gearmotor 18, keyed directly onto the first

10 drive pinion 19, to rotate not only about its own axis but also about the axis of the circular elements 6, as in the case of the pinions 19, 22, the gearmotor 18 is fixed to one of the arms 24 by a support piece 26 (Figure 4A) interposed between one of the two arms 24 and the gearmotor 18.

To enable articles, for example plastic bottles collected in groups, to be

15 more easily loaded onto the surface formed by the extended rolling shutter 7, a chute 29 can be used associated with the free end of the rolling shutter 7 and hence slidable with it; when in the extended portion the chute 29 abuts against a corresponding facilitation step 31 fixed to the two side walls 4 and lying perpendicular to it.

20 The unit 1 can be loaded by external pusher means or, preferably, by using loading means housed on the unit itself.

In the illustrated embodiment, and as visible in Figure 7, the loading means are in the form of a loading carriage 32 slidably associated with a pair of parallel opposing guides 28 provided on the inner side of the side

25 walls 4 of the framework 3.

The carriage 32 is made to slide along the guides 28 by three telescopic

arms, namely an inner arm 33a, intermediate arm 33b and outer arm 33c, with the inner arm 33a slidable within the guides 28.

Specifically, the intermediate arm 33b slides along a guide provided on the inner arm 33a in a manner not to interfere with this latter, whereas the 5 outer arm 33c slides inside the intermediate arm 33b.

A first bar 34 centrally supporting a first collection wall 35 of the loading carriage 32 is fixed perpendicular to the free ends of the outer arm 33c.

The intermediate arms 33b have fixed thereto the ends of a second rigid bar 36, positioned parallel to the first bar 34 and centrally supporting a 10 second collection wall 37 of the loading carriage 32 which faces the first wall 35.

Essentially, the two opposing collection walls 35, 37 of the loading carriage 32, which are positioned perpendicular to the side walls 4, are made to move relative to each other by the relative movement between 15 the outer arm 33c and the intermediate arm 33b.

Two opposing telescopic lateral walls of the carriage 32 are fixed perpendicular to the two opposing bars 34, 36, parallel to the telescopic arms 33a, 33b, 33c and to the side walls 4. Each lateral wall comprises two lateral telescopic arms 38a, 38b having their free ends slidably 20 associated with the respective opposing bars 34, 36.

Essentially, the lateral arms 38a, 38b, and hence the telescopic lateral walls, can slide not only in the longitudinal direction in compliance with the relative movement between the intermediate arm 33b and the outer arm 33c, but also perpendicular to their length, along the opposing bars 34, 36.

25 Said telescopic lateral walls are driven symmetrically to approach and withdraw from each other transversely by a pair of abutting pneumatic

cylinders 39 fixed centrally to one of the bars, namely to the bar indicated by 36 in the example.

Consequently, the collection space bounded by the carriage 32 can be determined on the basis of the space occupied by the bottles to be

- 5 loaded, by simply adjusting the relative distance between the telescopic lateral walls formed by the lateral arms 38a, 38b by means of the cylinders 39, and adjusting the relative distance between the remaining two walls 35, 37 by relative movement between the intermediate arm 33b and the outer arm 33c.
- 10 According to the present invention, the unit 1 is able to create pallets of products formed from several overlying layers. Some types of products require a layer of material known as a slip sheet to be interposed between two successive layers.

This is made possible by means for taking and releasing slip sheets 200 associated with the unit 1, to be placed on each layer of bottles to be palletized.

Said means for taking and releasing slip sheets, shown in Figure 8, comprise a pantograph structure 40 carrying a plurality of suckers 45 arranged to adhere to the surface of a supported slip sheet 200.

- 20 Said pantograph structure 40 comprises a fixed first frame 41, a vertically movable second frame 42, these being positioned horizontally parallel to each other, a third frame 43 and a fourth frame 44, these being disposed in X formation, interposed between the first frame 41 and second frame 42 and pivoted to enable the second frame 42, carrying the suckers, to move towards and away from the first frame 41.
- 25 The third frame 43 and fourth frame 44 have one of their ends hinged

respectively to the fixed first frame 41 and to the movable second frame 42, on a common vertical plane, which lies to the left in the example of Figure 8. They are also pivoted, with centre indicated by 50, close to the point in which they cross, while the remaining free ends, located to the 5 right in Figure 8, are each hinged to a slider 46 slidably associated with a guide 47 fixed respectively to the first frame 41 and to the second frame 42.

The movable second frame 42 is raised and lowered relative to the overlying fixed first frame 41 by a pair of toothed belts 48 of defined 10 length, fixed at one end to a pair of reels, not shown, fixed idly on a shaft positioned coaxial to the central fulcrum, and at their opposite end to a trolley 51 operated by a cylinder 52 for its sliding along a track 53 fixed to the first frame 41. Between the trolley 51 and the reels on which the respective ends of the belts 48 are fixed, a pair of toothed pulleys 49 are 15 interposed, about which the belts 48 travel. Said pulleys are positioned centrally on the fixed first frame 41.

Essentially, the second frame 42 is raised by operating the cylinder 52 to push the trolley 51 which drags with it the belts 48, these acting to fold the third frame 43 and fourth frame 44 to hence raise the second frame 42 20 and move the fulcrum 50 close to the pulleys 49.

In other words, the third frame 43 and the fourth frame 44 move as scissors pivoted on the centre 50 and operated by the cylinder 52.

The trolley 51 and the third frame 43 and fourth frame 44 slide in a direction perpendicular to the side walls 4.

25 In the illustrated example, the suckers 45 are five in number, of which four are disposed at the corners of the second frame 42 and one disposed

centrally, supported by a small frame. Each sucker 45 is connected to a venturi valve 54 which on taking the slip sheet 200 creates and maintains a vacuum within the sucker 45 to obtain a perfect seal with the slip sheet 200. To release the slip sheet 200, the valves 54 again put the cavity 5 between the sucker 45 and slip sheet 200 "under pressure" to hence cause this latter to fall.

As the slip sheets 200 are stacked, it may happen that because of an engulfing effect, when a slip sheet 200 is picked up, that underneath is also involuntarily picked up. To overcome this drawback, a cylinder 55 is 10 used for each sucker 45. Said cylinders 55 are operated to create, after the slip sheet 200 has been picked up, a disordered movement of the five suckers 45, to hence release any slip sheet involuntarily sucked up.

According to the preferred embodiment of the present invention and as shown in Figure 9, the unit 1 further comprises means for taking and 15 releasing retention surrounds 300 to place on the top of the rows of bottles positioned on the pallet.

Said means for taking and releasing surrounds comprise two pairs of opposing rocker members 60, each rocker member 60 consisting in the example of a rigid pair of parallel arms 61. Said rocker members are 20 centrally pivoted to the ends of a pair of brackets 62 fixed, parallel to the side walls 4, to the two opposing sides of the vertically movable second frame 42. Each rocker member 60 is rotated, about rotation pins 63 having horizontal axes perpendicular to the side walls 4, by a cylinder 64 pivoted centrally to the bracket 62 and with the end of the piston rod 25 pivoted on one end of the rocker member 60. At the opposite end to that pivoted to the piston rod of the cylinder 60, each rocker member 60

carries a resting piece 65 which abuts against the upper wall of the surround 300 to be picked up.

A slide member 66 is mounted slidable on the parallel arms 61 of each rocker member 60 and is operated by a cylinder 67 also pivoted at the 5 same point as the corresponding rocker member 60.

Each slide member 66 is fixed to a lower base 69 carrying engagement means comprising a pair of resilient conical elements 68 disposed such as to be able to engage the inner wall of the surround 300. The bases 69 are fixed to the end of the piston rod of the cylinders 67 which operate the 10 slide member 66.

Essentially, the rocker member 60 intercepts the surround 300 to be picked up by means of the resting piece 65, while the resilient conical elements 68, guided by the slide member 66 along the parallel arms 61 of the rocker member 60, engage the surround 300 to be raised, aided by 15 the cylinders 64.

In operation, the unit 1 picks up a slip sheet 200 by means of the suckers 45; the cylinders 55 are operated to allow any involuntarily picked-up slip sheets to fall, after which the picked-up slip sheet is raised by operating the cylinder 52, which by means of the belts 48 raises the pantograph structure 40 carrying the suckers 45 to which the slip sheet 200 is 20 attached. The unit 1 with the slip sheet 200 carried by it moves above the groups of bottles to be loaded by the movable carriage 32 already positioned jutting from the side walls 4 and with the rolling shutter 7 in its extended position. When the carriage 32 is positioned above the bottles 25 to be withdrawn, the unit is lowered to enclose the bottles within the lateral walls of the carriage 32, taking care that the surface of the rolling shutter

is coplanar with the surface on which the bottles to be withdrawn lie.

At this point the carriage 32 moves towards the rolling shutter 7 to hence load the bottles onto the unit 1.

The cylinder 52 is operated to move the slip sheet 200 above the layer of

5 bottles just loaded.

With the bottles loaded and the slip sheet positioned on top of them, the unit moves above the pallet and the rolling shutter 7 is rolled up about the circumferential portions to cause the layer of bottles with the slip sheet 200 on top to fall through the aperture and onto the pallet.

10 The slip sheet 200 is released from the suckers by operating the valves 45.

This cycle is repeated until the number of rows of bottles to be loaded onto the pallet has been reached. Before the last loading cycle, the unit picks up the surround 300 by moving above it and operating the cylinders 15 62 until the four resting pieces 65 bear against the upper wall of the surround 300. At this point the cylinders 67 are operated to thrust the four pairs of resilient conical elements 68 against the inner wall of the surround 300, which is hence raised with the aid of the simultaneous operation of the cylinders 64, and moved to a height such as not to constitute an 20 obstacle to the subsequent withdrawal of the slip sheet 200 and of the bottles.

In practice, the handling unit 1 enables all the operations involved in palletizing to be carried out with minimum space requirements and with extreme efficiency in executing the various operations.

25 In a second embodiment of the invention, the unit, indicated by 1', comprises two facing rolling shutters 7' which slide respectively along a

pair of opposing facing rails 5' (Figure 6).

The lower aperture is closed by positioning the two rolling shutters 7' in mutual abutment along the central line through the aperture.

Essentially, the two rolling shutters 7' are made to approach each other to

5 close the aperture and to withdraw to open it.

The drive means can be the same as those used for the unit 1 of the first embodiment and will therefore not be further described.

To prevent the articles pushed onto the rolling shutters 7' from being dragged as these latter slide apart, a pair of movable stops 30 are used,

10 operated by suitable means of known type.

As will be appreciated from the foregoing description, the handling unit of the invention enables all palletizing operations to be effected, including positioning of the slip sheets and the surrounds. This is achieved by a single compact and extremely versatile unit.

15 An expert of the art can apply numerous modifications and variants to the aforescribed handling unit to satisfy specific contingent requirements, all of which however are contained within the scope of protection of the invention, as defined by the following claims.

CLAIMS

1. A handling unit (1) for palletizing, characterised by comprising:
 - a support (2) for coupling to manipulator means;
 - a framework (3) associated with said support (2) and defining an aperture;
 - a pair of parallel opposing slide rails (5) fixed to said framework (3);
 - at least one flexible sliding panel (5) slidable along said rails (5) between an extended position in which it completely closes said aperture to enable it to support articles to be palletized, and a retracted position in which it opens said aperture to enable said articles to fall through said aperture;
 - drive means (18, 19) for sliding said panel (7) along said rails (5).
2. A handling unit (1) as claimed in claim 1, wherein a first section of said rails (5) extends along two opposing circumferential portions and a second section thereof extends along two horizontal opposing portions, said rolling shutter (7) occupying only the first section extending along the two circumferential portions when in its retracted position.
3. A handling unit (1) as claimed in claim 2, wherein said rolling shutter (7) occupies only the second section extending along the two horizontal portions when in the extended position
- 20 4. A handling unit (1) as claimed in claim 2, wherein said framework (3) comprises a pair of vertical opposing side walls (4) defining said aperture.
5. A handling unit (1) as claimed in claim 4, wherein said horizontal portions of the second section of the rails (5) are fixed to the inner sides of the pair of side walls (4).
- 25 6. A handling unit (1) as claimed in claim 2, wherein said drive means comprise at least one movable motor (18) rotating a first movable drive

pinion (19) engaging a first fixed circumferential rack (20) with which one of the opposing circumferential portions of the first section of the rails (5) is associated.

7. A handling unit (1) as claimed in claim 6, wherein said first drive pinion (19) is axially keyed via a shaft (21) to a second movable pinion (22) engaging a second fixed circumferential rack (23) with which the remaining opposing circumferential portions of the first section of the rails (5) are associated.

8. A handling unit (1) as claimed in claim 7, wherein said first pinion (19) and said second pinion (22) are maintained constantly engaged with said first rack (20) and with said second rack (23) respectively, by a pair of rigid arms (24) rotatably associated with a pair of circular elements (6) coaxial with the circumferential portions of the first section of the rails (5).

9. A handling unit (1) as claimed in claim 8, wherein said first pinion (19) and said second pinion (22) are respectively associated with one end of said sliding panel (7) by a pair of opposing connecting rods (25).

10. A handling unit (1) as claimed in claim 1, wherein said sliding panel comprises a plurality of parallel cylindrical rods transverse to the sliding direction, connected together in pairs by offset chain links (9, 10).

11. A handling unit (1) as claimed in claim 10, wherein the ends of said rods (8) are rotatably associated with wheels (16) which roll within said rails (5).

12. A handling unit (1) as claimed in claim 1, comprising loading means for dragging articles to be palletized onto said panel (7) when in its extended position.

13. A handling unit (1) as claimed in claim 12, wherein said loading

means comprise a loading carriage (32) slidably associated with the framework (3).

14. A handling unit (1) as claimed in claim 13, wherein said loading carriage (32) presents a quadrangular configuration with its opposing 5 sides adjustable towards and away from each other.

15. A handling unit (1) as claimed in claim 1, further comprising means for taking and releasing slip sheets.

16. A handling unit (1) as claimed in claim 15, wherein said means for picking up and releasing slip sheets comprise a pantograph structure (40) 10 carrying a plurality of suckers (45) for adhering to the surface of a slip sheet (200).

17. A handling unit (1) as claimed in claim 16, wherein said suckers (45) are associated with venturi valves (45) for creating vacuum within the cavities of the suckers (45).

18. A handling unit (1) as claimed in claim 16, wherein each sucker (45) 15 is driven by a cylinder (55).

19. A handling unit (1) as claimed in claim 1, further comprising means for picking up and releasing surrounds.

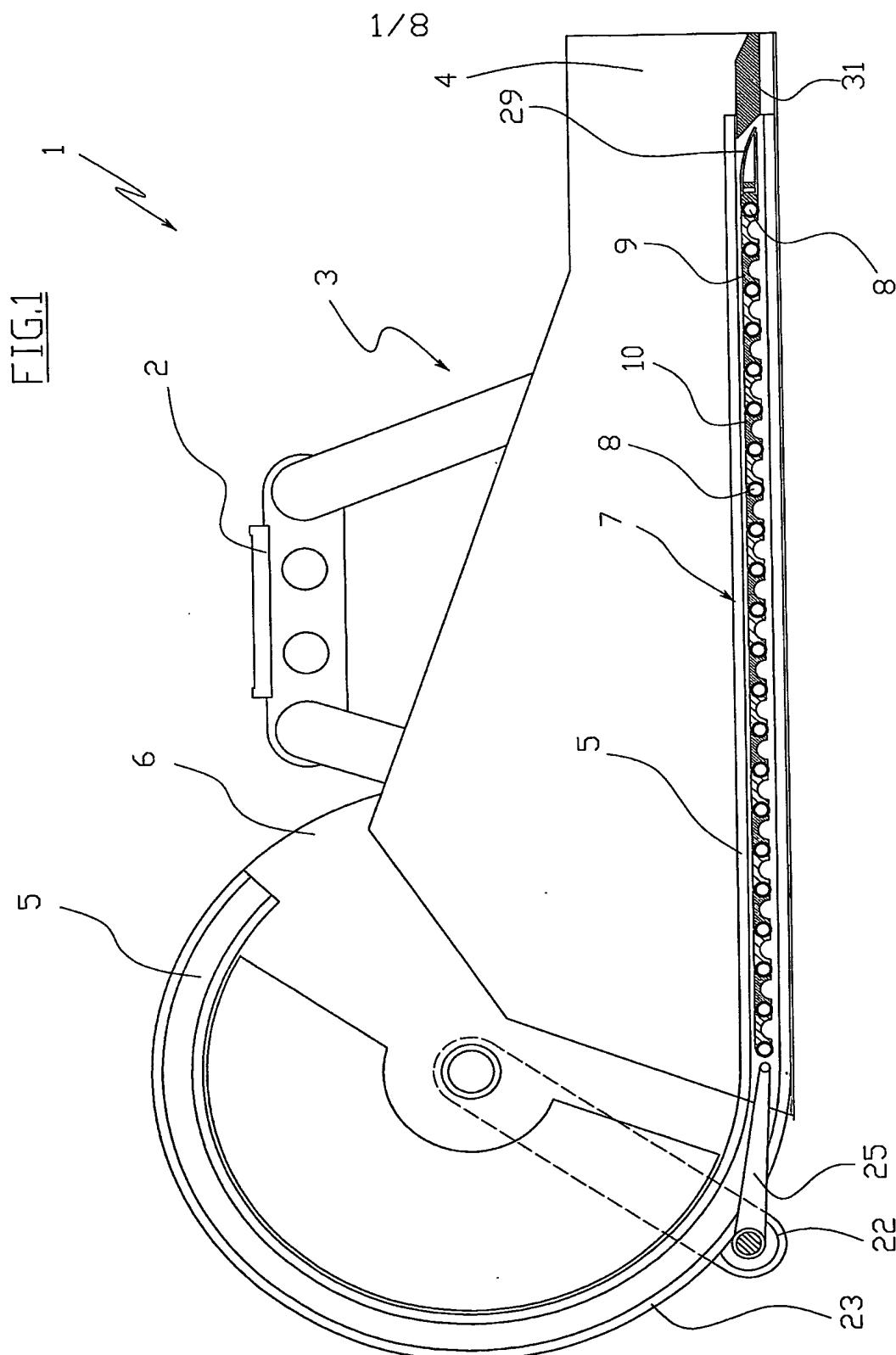
20. A handling unit (1) as claimed in claim 19, wherein said means for picking up and releasing surrounds comprise two opposing pairs of rocker 20 members (60) with which means (68) are associated for engaging the surround.

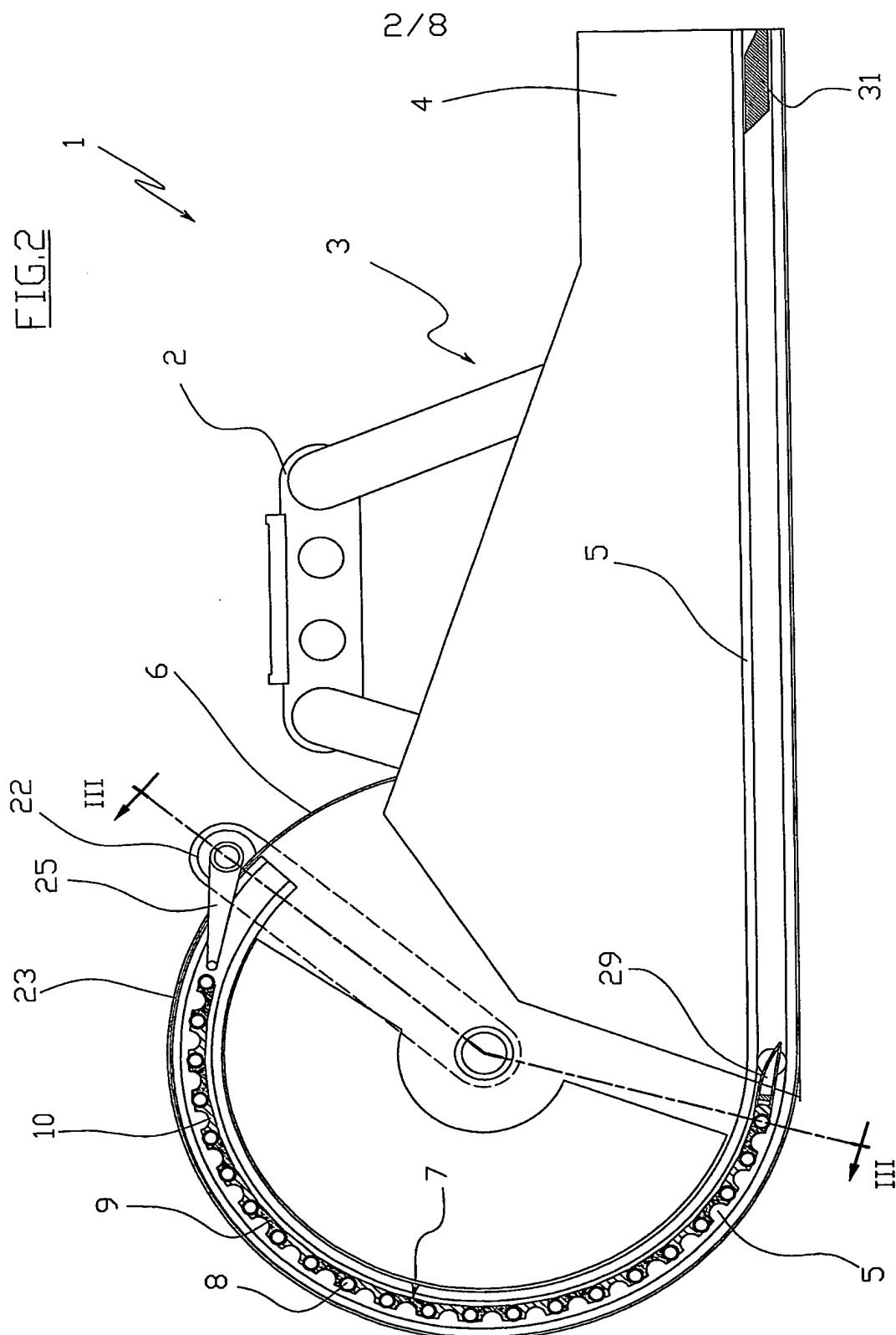
21. A handling unit (1) as claimed in claim 20, wherein said rocker members (60) are pivoted on a pair of plates (62) which can be moved 25 upwards away from the aperture and downwards towards the aperture.

22. A handling unit (1) as claimed in claim 1, comprising a pair of

mutually facing sliding panels (7') slidable along a pair of mutually facing rails (5) between a position in which said panels (7') are positioned mutually abutting to completely close said aperture and a retracted position in which they are mutually withdrawn to open said aperture.

- 5 23. A handling unit (1) as claimed in claim 1, wherein said manipulator means comprise a robot.
24. A palletizer robot comprising a handling unit in accordance with claim 1.





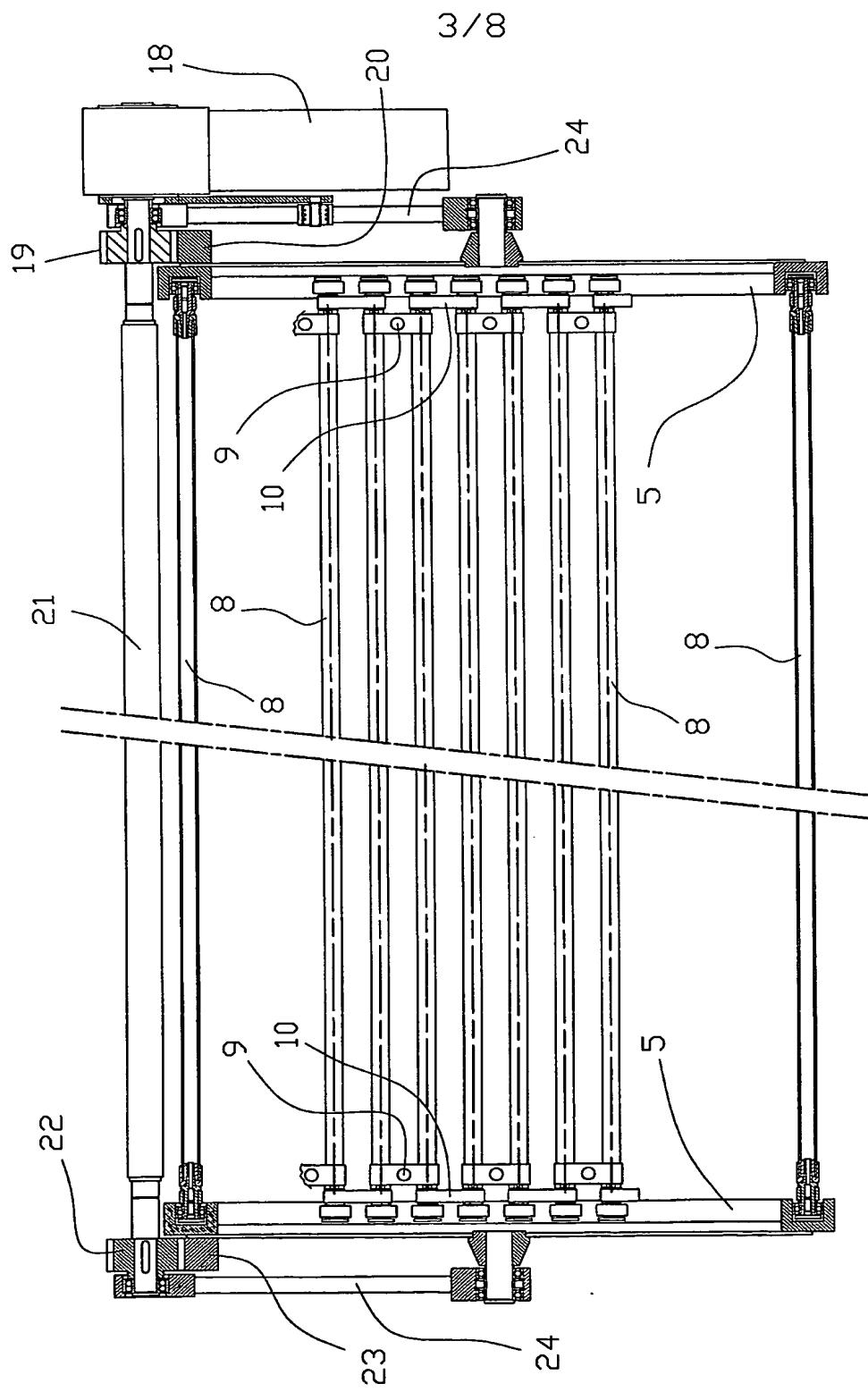
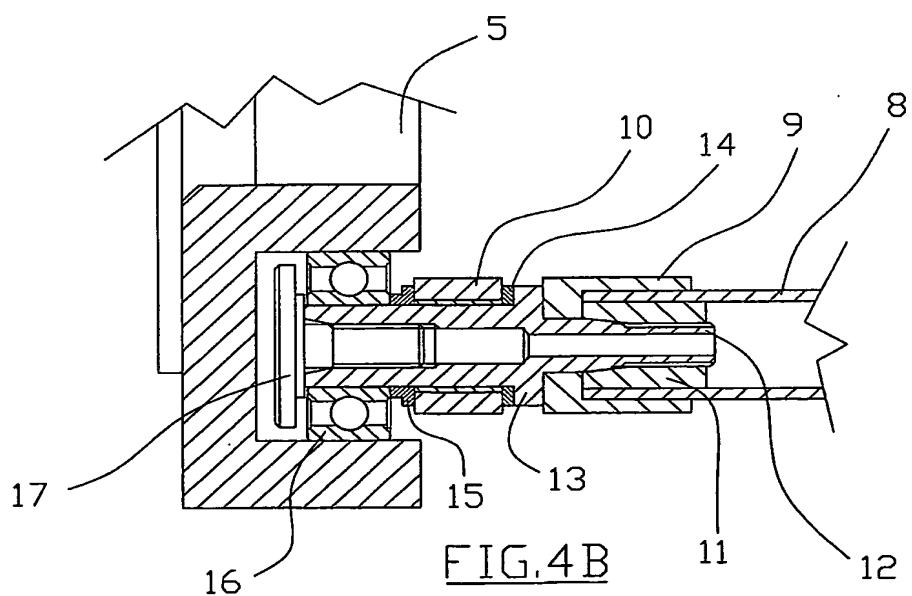
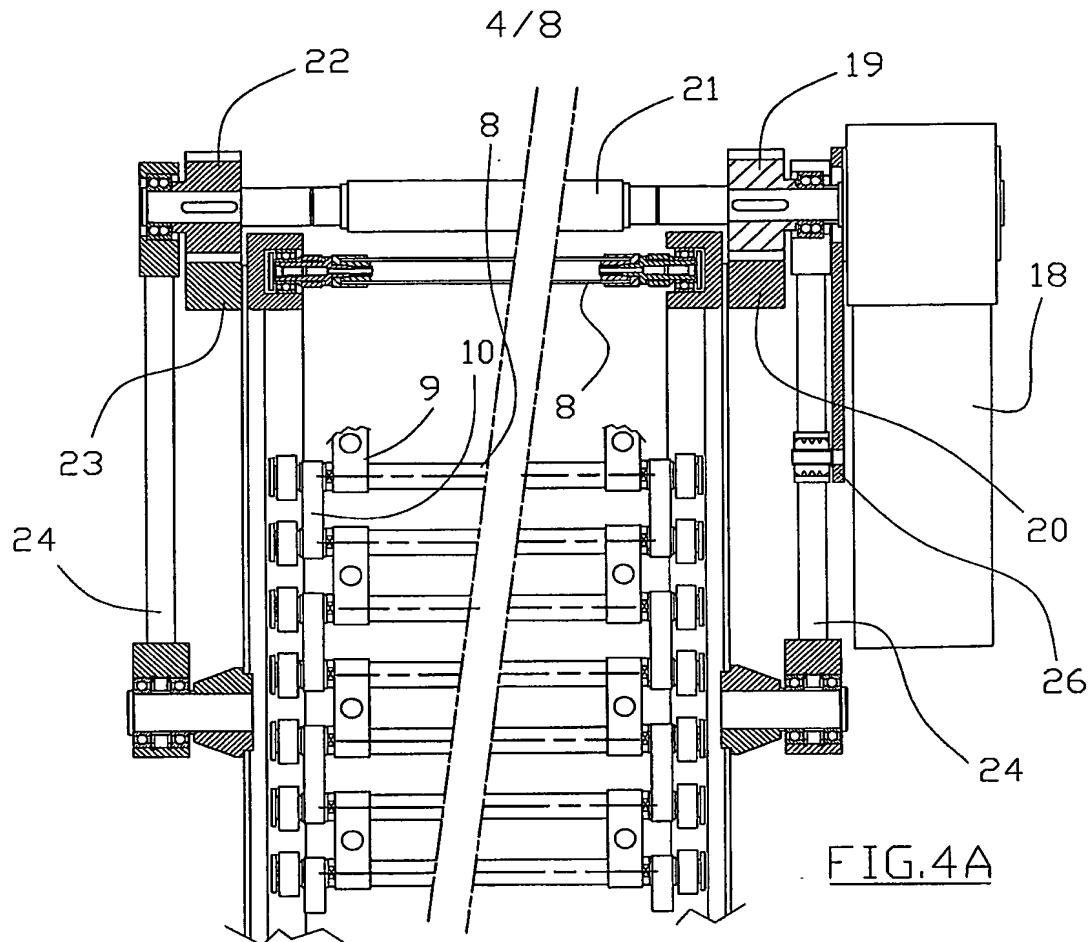
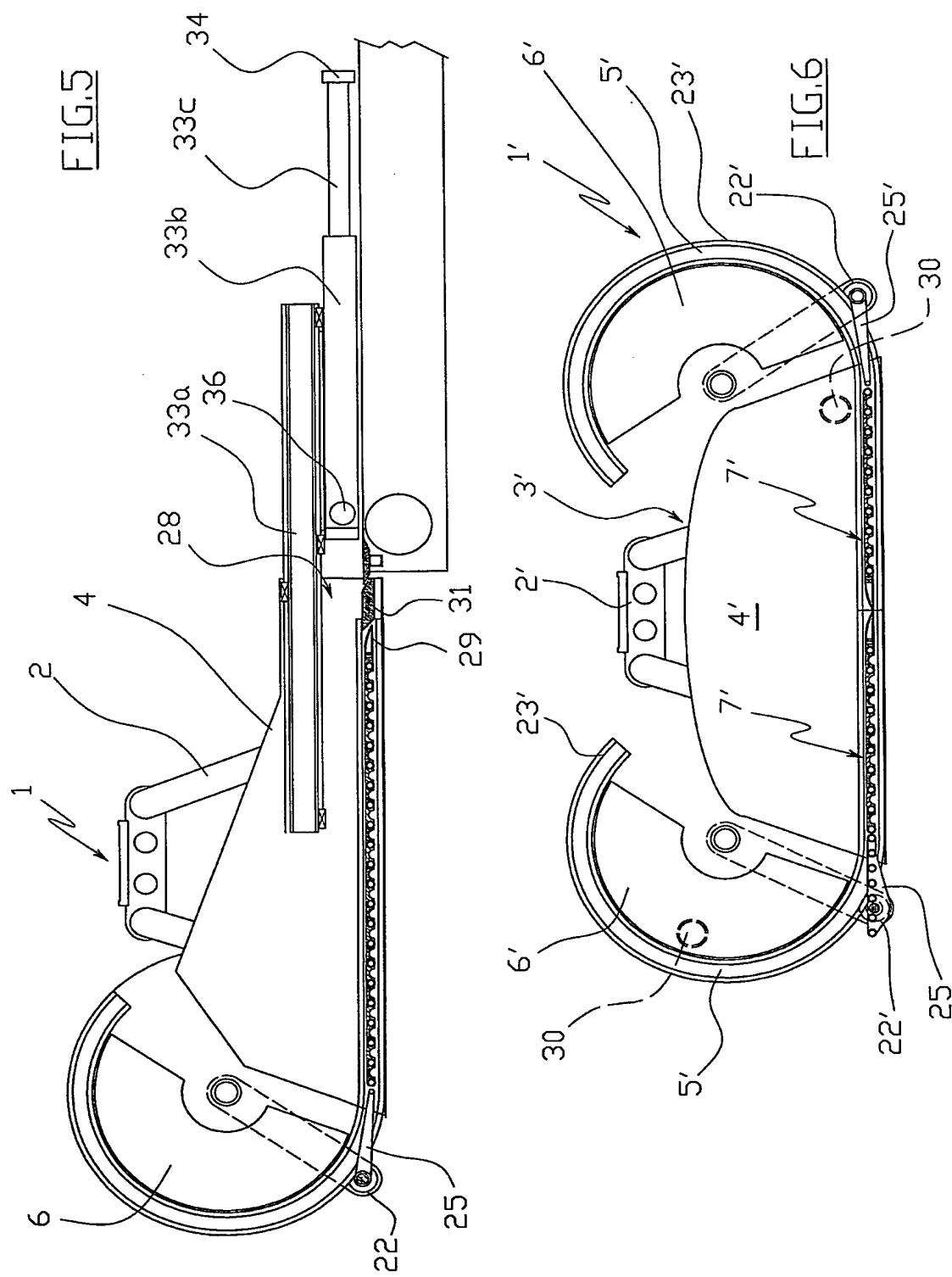


FIG.3

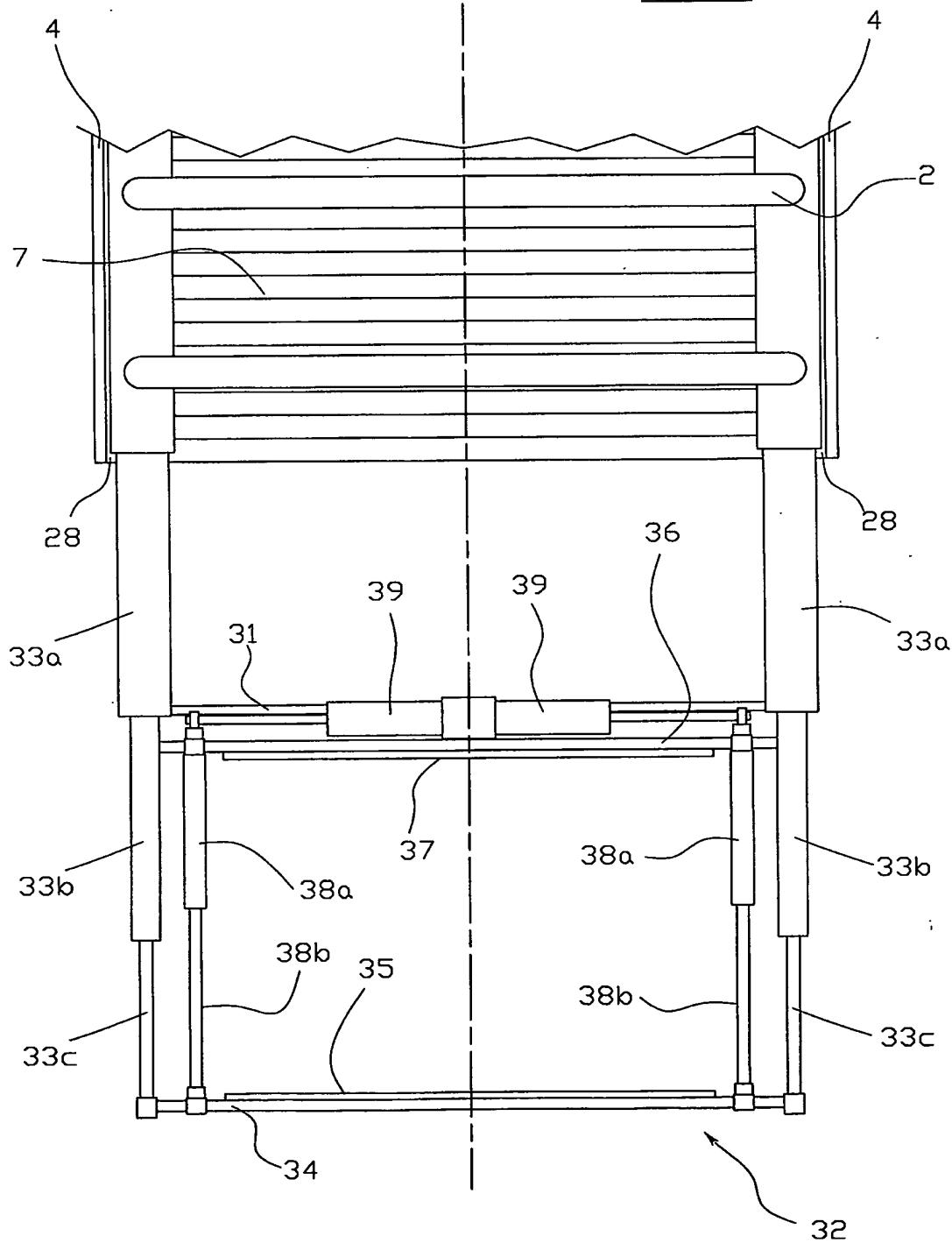


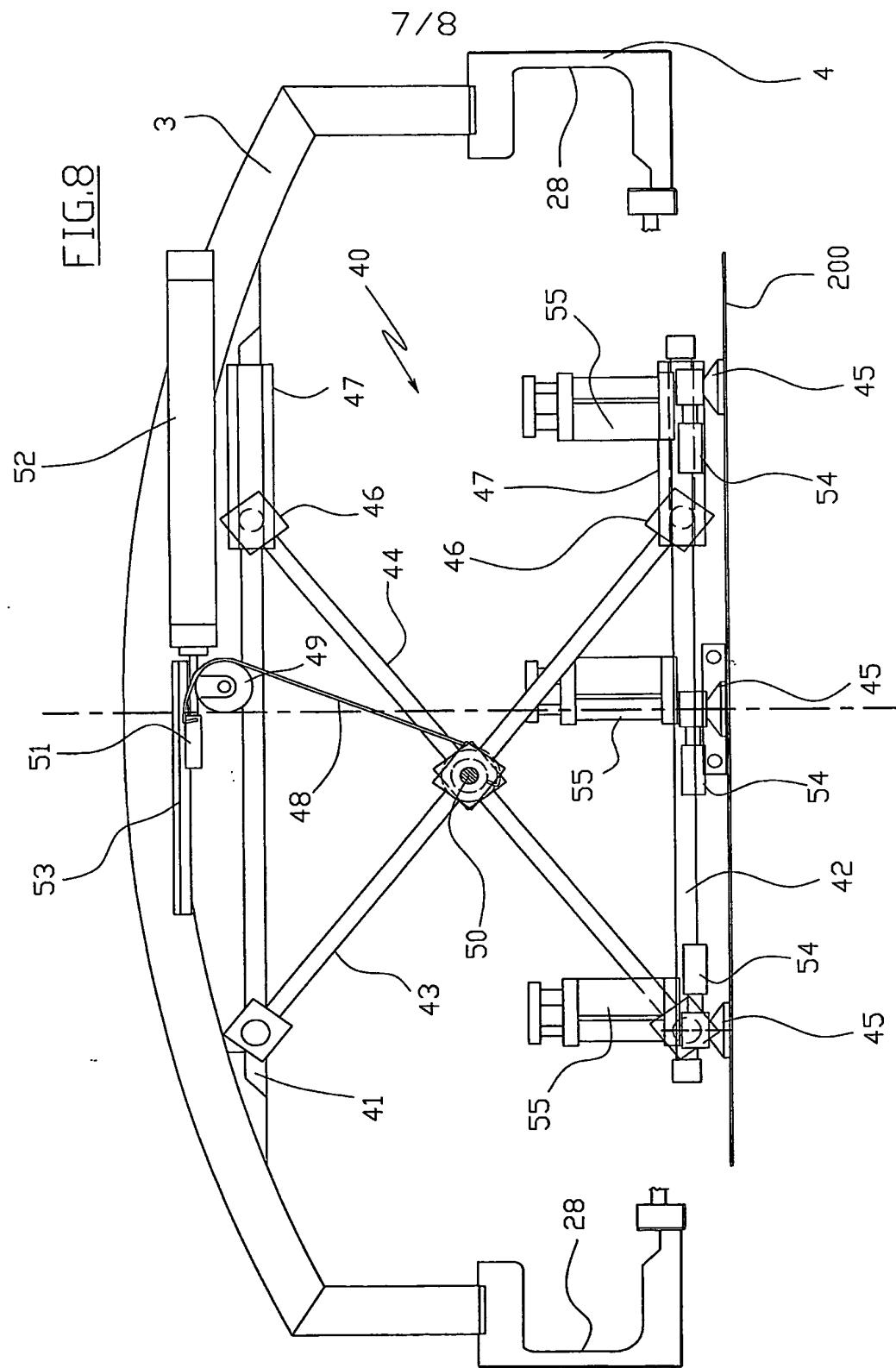
5/8

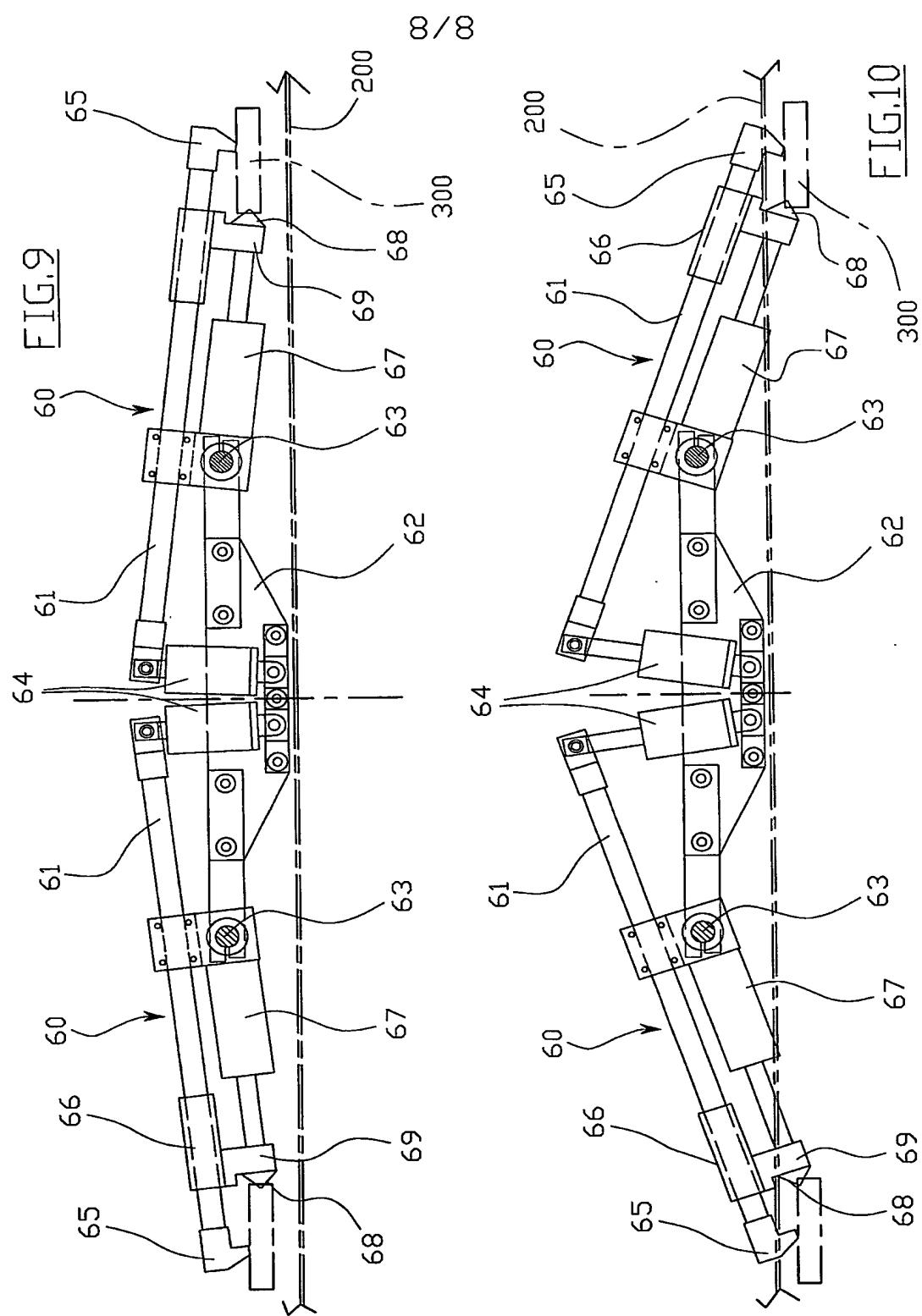


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FIG. 7







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(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, UZ, VC, VN, YU, ZA, ZM, ZW, ARIPO patent (BW, GH, GM, KE, LS, MW, MZ,

GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

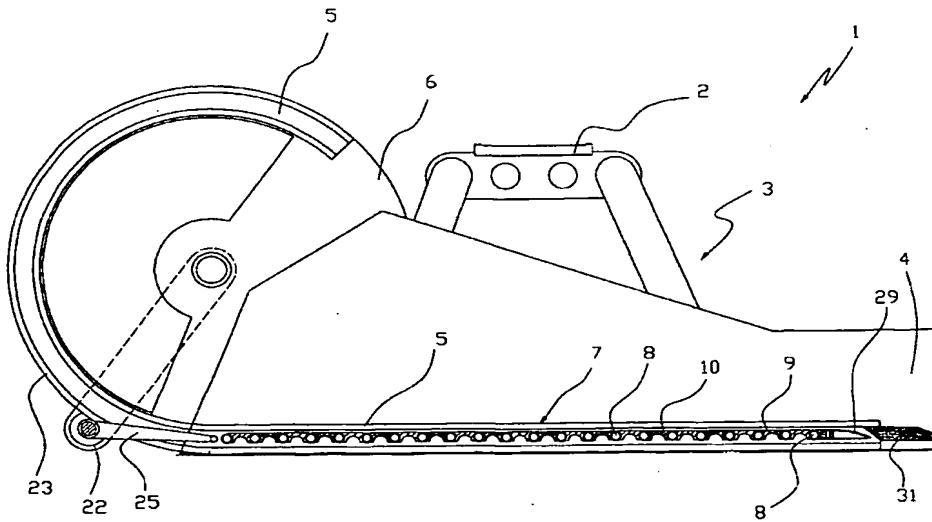
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[Continued on next page]

(54) Title: HANDLING UNIT FOR PALLETIZING



(57) Abstract: A handling unit (1) for palletizing, comprising: - a support (2) for coupling to manipulator means; - a framework (3) associated with said support (2) and defining an aperture; - a pair of parallel opposing slide rails (5) fixed to said framework (3); - at least one flexible sliding panel (5) slidable along said rails (5) between an extended position in which it completely closes said aperture to enable it to support articles to be palletized, and a retracted position in which it opens said aperture to enable said articles to fall through said aperture; - drive means for sliding said panel (7) along said rails (5).

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NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG)

- as to the applicant's entitlement to claim the priority of the earlier application (Rule 4.17(iii)) for the following designations AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, UZ, VC, VN, YU, ZA, ZM, ZW), ARIPO patent (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR,

GB, GR, HU, IE, IS, IT, LT, LU, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG)

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International Application No
PCT/IB2005/001124

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B. FIELDS SEARCHED

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Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EP0-Internal, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 1 457 442 A (OMA S.R.L) 15 September 2004 (2004-09-15) paragraph [0032] - paragraph [0035]; figures paragraph [0073] - paragraph [0075] -----	1,10-13, 23,24 15,19
Y	US 4 978 275 A (REID ET AL) 18 December 1990 (1990-12-18) column 3, line 12 - line 44; figure 1 -----	15,19
X	GB 2 066 201 A (HOLSTEIN UND KAPPERT GMBH) 8 July 1981 (1981-07-08) page 1, line 119 - page 2, line 19; figures ----- -/-	1,10, 22-24

Further documents are listed in the continuation of box C.

Patent family members are listed in annex.

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Date of the actual completion of the International search

Date of mailing of the International search report

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Schneider, M

INTERNATIONAL SEARCH REPORT

International Application No
PCT/IB2005/001124

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 0 257 447 A (MEYPACK VERPACKUNGS- UND PALETTIERTECHNIK GMBH) 2 March 1988 (1988-03-02) column 6, line 36 - column 8, line 42; figures ----- PATENT ABSTRACTS OF JAPAN vol. 017, no. 120 (M-1379), 12 March 1993 (1993-03-12) -& JP 04 303327 A (ANRITSU CORP), 27 October 1992 (1992-10-27) abstract; figures -----	1,10,22
X	US 6 533 533 B1 (HESTON STEPHEN L) 18 March 2003 (2003-03-18) column 16, line 18 - column 17, line 6; figure 15 -----	1,23,24
X	US 6 533 533 B1 (HESTON STEPHEN L) 18 March 2003 (2003-03-18) column 16, line 18 - column 17, line 6; figure 15 ----- EP 1 321 396 A (OMA S.R.L) 25 June 2003 (2003-06-25) paragraph [0034] - paragraph [0045]; figures -----	1,10
		1,12,13, 22

INTERNATIONAL SEARCH REPORT

International application No.
PCT/IB2005/001124

Box II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. Claims Nos.: because they relate to subject matter not required to be searched by this Authority, namely:

2. Claims Nos.: because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:

3. Claims Nos.: because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.

2. As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.

3. As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:

4. No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

The additional search fees were accompanied by the applicant's protest.

No protest accompanied the payment of additional search fees.

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 1-11,22-24

Handling unit for palletizing

1.1. claims: 1-9

Handling unit for palletizing, wherein the rails extends along two circumferential portions

1.2. claims: 10,11

Handling unit for palletizing, wherein the sliding panel comprises parallel cylindrical rods connected together in pairs by offset chains

1.3. claim: 22

Handling unit for palletizing, comprising a pair of mutually facing sliding panels

1.4. claims: 23,24

Handling unit for palletizing, wherein the manipulator means comprises a robot and palletizer robot

2. claims: 12-14

Handling unit for palletizing comprising loading means

3. claims: 15-18

Handling unit for palletizing comprising means for taking and releasing slip sheets

4. claims: 19-21

Handling unit for palletizing comprising means for picking up and releasing surrounds

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/IB2005/001124

Patent document cited in search report		Publication date	Patent family member(s)		Publication date
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